

Date: Thursday, 6/21/2007 2:35:01 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LUG BRACKET			
Job Number	33091	Part Number	D27353			
Estimate Number	10010	Drawing Number	D2735 REV C			
P.O. Number	N/A	Project Number	N/A			
This Issue	6/21/2007	S.O. No.	N/A			
Prsht Rev.	NC	Type	SMALL /MED FAB			
First Issue	N/A	Material	N/A			
Previous Run	32771	Due Date	7/5/2007	Qty:	30	
Written By	JLM					Um: Each
Checked & Approved By	JLM					
Comment	Est Rev:C Removed from 9 Digit 05-10-25 Est. C 06.07.21 waterjet EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125
		Comment: Qty.: 0.1733 sf(s)/Unit Total : 5.1975 sf(s) 1010-1025 sheet .125 batch: M104699 SAM 07/06/23
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2735 Dwg Rev: C Prog Rev: C 2-Deburr if necessary SAM 07/06/23 23
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAM 07/06/23 33
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK En 07/06/25 (33)
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required. SB 07/06/27 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/29
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:35:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 33091

Part Number: D27353

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



(Counted)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

4.06.27

8.0 QC21 FINAL INSPECTION/W/O RELEASE



(33)

Comment: FINAL INSPECTION/W/O RELEASE

4.06.29

Job Completion



4.06.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<u>33091</u>
Description: Lug Bracket	Part Number:	<u>D2735-3</u>
Inspection Dwg: D2735 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>SAN</u>	Audited by: <u>EN</u>	Prototype Approval: N/A
Date: <u>07/06/23</u>	Date: <u>07/06/25</u>	Date: N/A

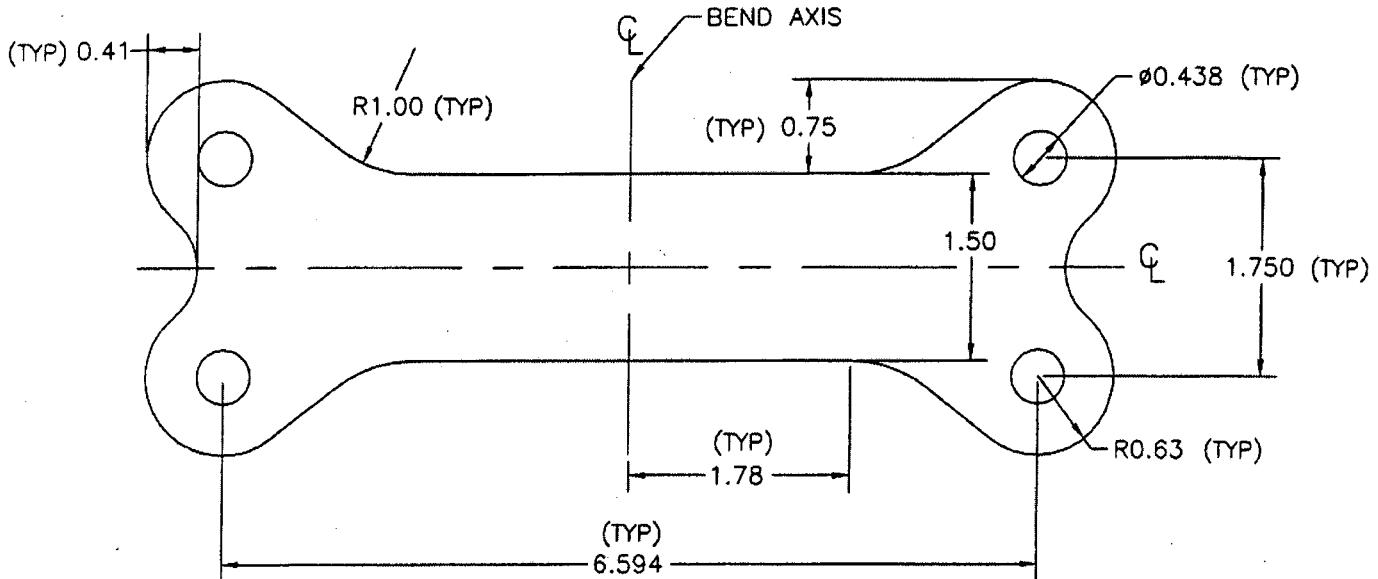
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	<i>[Signature]</i>



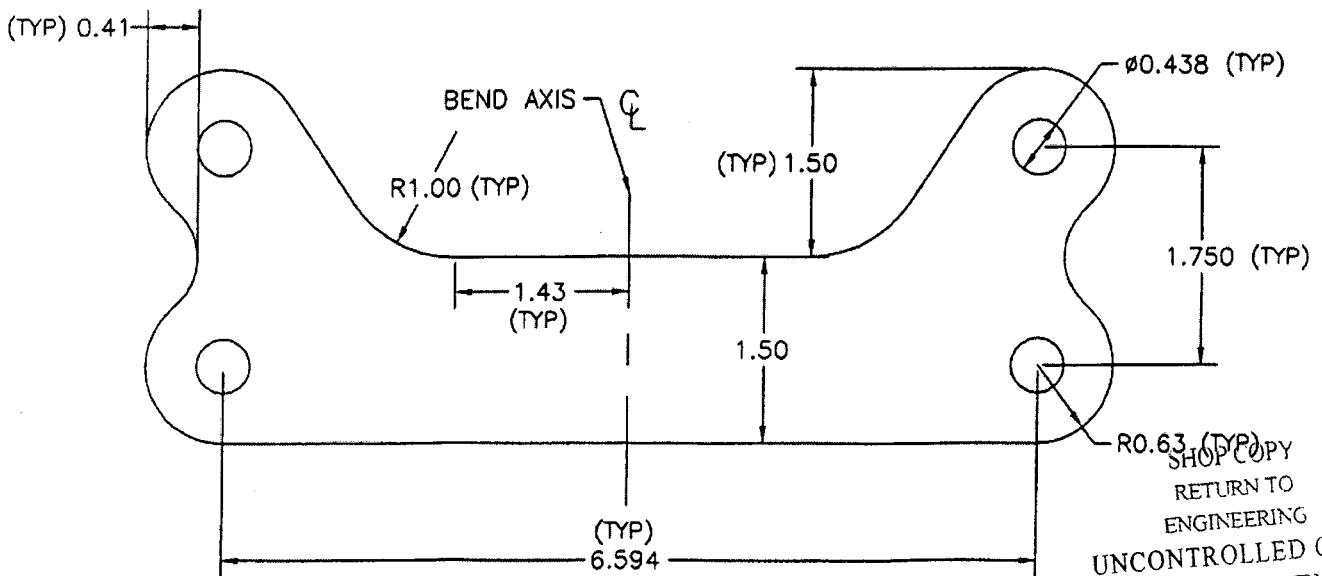
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2735 REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET SCALE 2:3

A	97.12.14	NEW ISSUE
B	98.10.23	UPDATE MATERIAL (TSR A1114)
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)



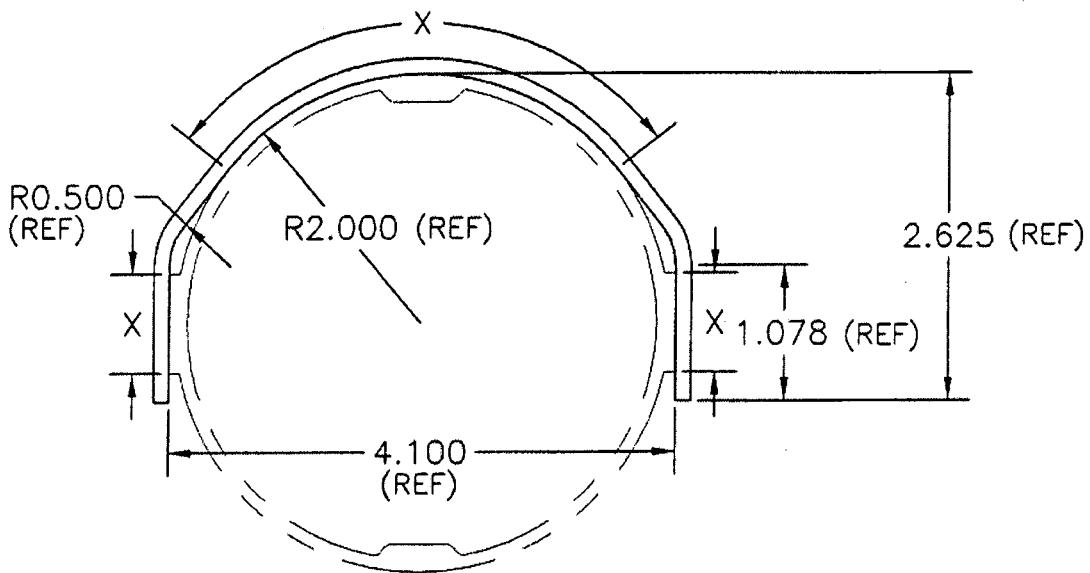
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33071



DESIGN <i>SH</i>	DRAWN BY <i>SH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735
DATE 98.12.14		TITLE LUG BRACKET

REV. C
SHEET 2 OF 2
SCALE
2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33091